

Work Order ID 83927

April-27-12 11:22:58 AM

Ship May 9

83927

Page 1

Item ID: D3866-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Plate

Stop *NS2*

Start Date: 27/04/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 08/05/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/04/12

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
<u>A 3866</u>	<u>A</u>					<u>6</u>			
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							<u>1312-5-1</u>
FLOW CNC Waterjet	1-Cut as per Dwg D3866								
<u>6061.125</u>	Dwg Rev: <u>A</u>								
	Prog Rev: <u>B</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							<u>1312-5-1</u>
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00				<u>(x3)</u>			
Quality Control									

Sizelstol

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

83927

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

2

2

Reference:

Run Start *NR1*

Stop *NR2*

Accept Qty	Reject Qty	Reject Number	Insp. Stamp
------------	------------	---------------	-------------

0.00

0.00

Memo- - -

1- deburr

2- form as per dwg D3866

0.00

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

Chemical Conversion Coat per QSI005 4.1

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

83927

Page 3

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 27/04/2012 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 08/05/2012 **Req'd Qty:** 2.00 ***~***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location SI

0.00

170

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

3 of BL 12-5-7

3x 80
12-58

12/5/99

ME
12-05-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

April-27-12 11:23:02 AM

Page 1

Work Order ID: 83927

83927

Parent Item: D3866-1

D3866-1

Parent Item Name: Plate

Start Date: 27/04/2012

Required Date: 08/05/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 09-01-19 as per prelim issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	113.1500	0.06	0.12	5		

M6061T6S 125

6061-T6 .125 Sheet

**

1812-5-1

Location

Loc Qty

Loc Code

MAT021

113.15

120218

3.21

121473

109.94

120218

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

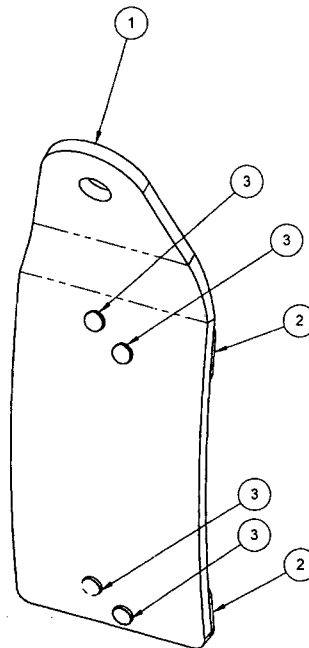
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -041
1	D3866-1	MOUNT	1
2	D3868-1	SPACER	2
3	MS20426AD3-6	RIVET	4



D3866-041 MOUNT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 83927 MLJ
12/04/27

RELEASED
07/12/29 MLJ

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3866-041" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs

A	NEW ISSUE	09.01.13
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.01.13	

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3866** REV. A
SHEET 1 OF 6

TITLE **MOUNT** SCALE
NTS

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

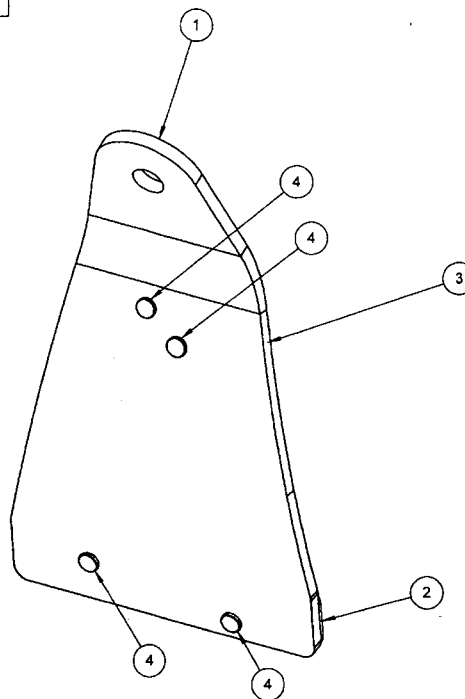
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -043
1	D3866-3	MOUNT	1
2	D3868-3	SPACER	1
3	D3868-5	SPACER	1
4	MS20426AD3-6	RIVET	4



D3866-043 MOUNT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3866-043" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.13 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3866	SHEET 2 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MOUNT	NTS
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RELEASED
[Handwritten: 09/01/13]

[Handwritten: 03927]

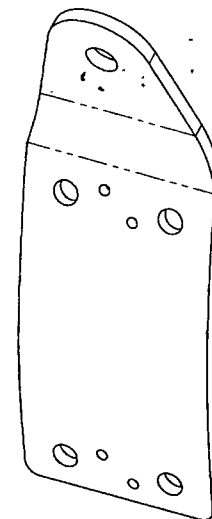
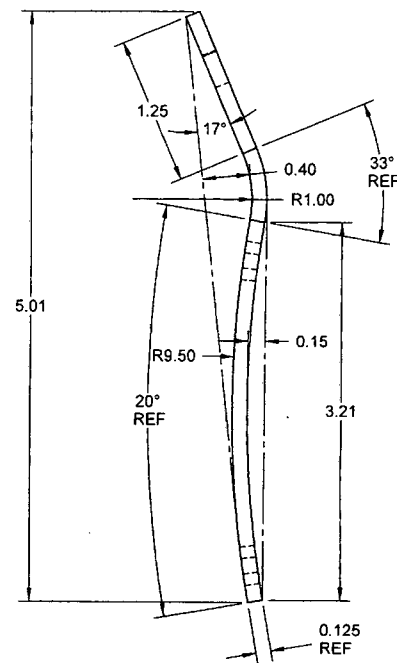
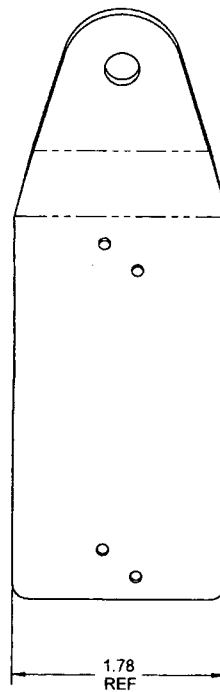
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3866-1 PLATE
MADE FROM D3866-1F

RELEASED
9/21/29 JH

NOTES:

- 1) MATERIAL: MADE FROM D3866-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

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MFG. APPR.		D3866	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		MOUNT	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

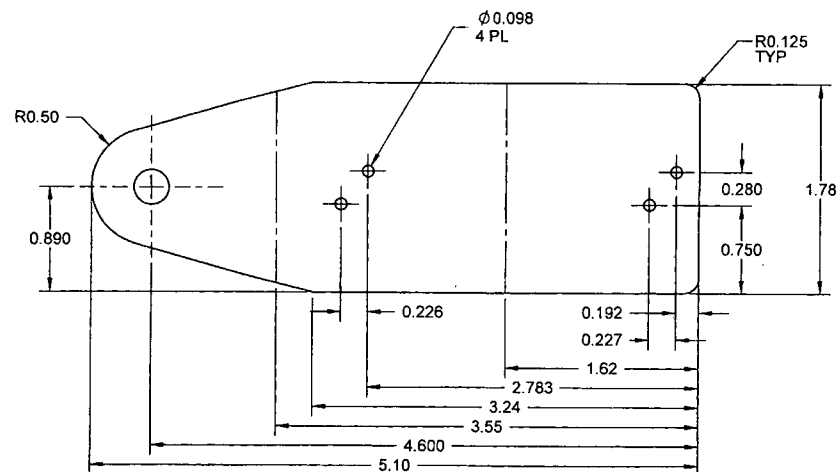
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

83927



D3866-1F PLATE FLAT PATTERN

RELEASED
07/01/13

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN	1	DART AEROSPACE LTD	
DRAWN	1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1	DRAWING NO.	REV. A
MFG. APPR.	1	D3866	SHEET 4 OF 6
APPROVED	1	TITLE	SCALE
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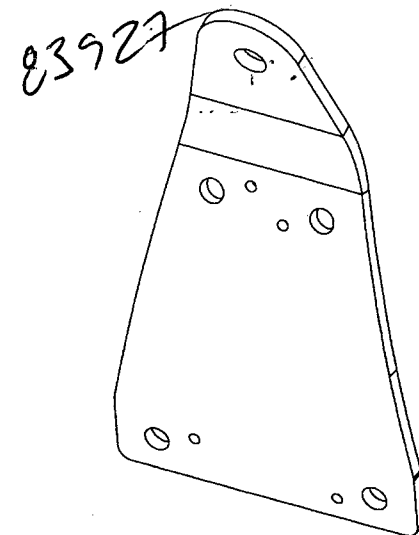
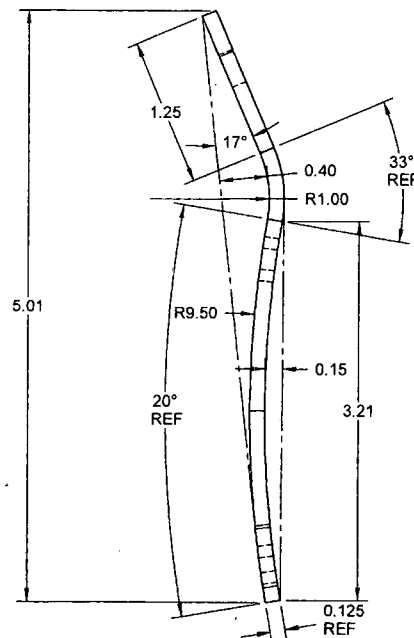
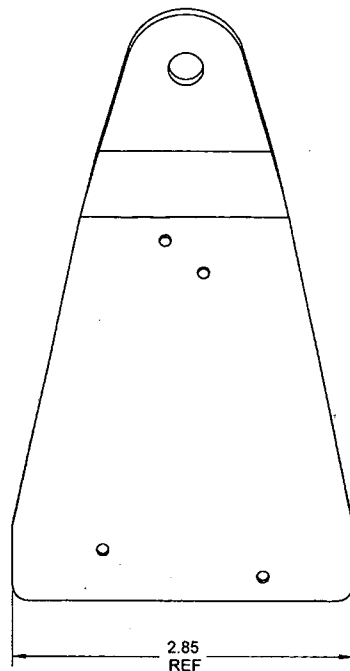
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3866-3 PLATE
MADE FROM D3866-3F

RELEASED
09/01/13

NOTES:

- 1) MATERIAL: MADE FROM D3866-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.12 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3866	SHEET 5 OF 6
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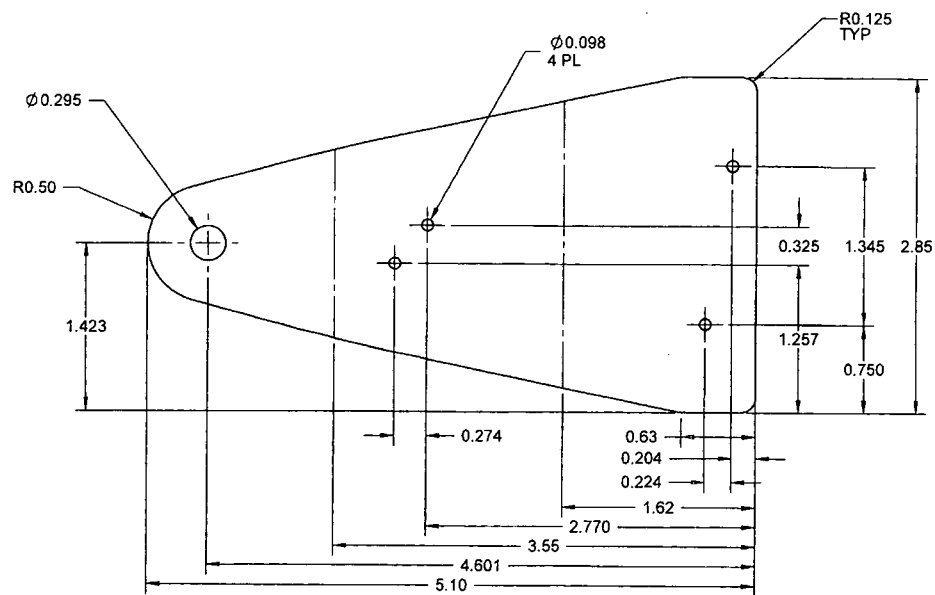
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NOTE: Date & initial all entries

03927



D3866-3F PLATE FLAT PATTERN

RELEASED
07/01/13

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.12 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3866 REV. A
MFG. APPR.		SHEET 6 OF 6
APPROVED		TITLE MOUNT SCALE NTS
DE APPR.		
DATE	09.01.13	

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